

Work Order ID 71223

Friday, June 24, 2011 11:19:46 AM



Page 1

Item ID: D3182-1

Accept



Setup Start



Revision ID:

Item Name: Hinge

Stop



Start Date: 6/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1106-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3182	Rev A

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304 . 125

1-Cut as per Dwg D3182 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

B11-6-27

(6)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

120



QC8- Inspect parts - second check

QC

Quality Control



0.00

S w106127

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

0.00

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150



Packaging

Identify as per dwg & Stock Location: WA

0.00

0.00

SAD 11-06-27

(b)

Packaging

Memo

*****STOCK IN BASKET CELL*****

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/06/28 9:00

MF
11-06-28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, June 24, 2011 11:19:52 AM

Page 1

Work Order ID: 71223



Parent Item: D3182-1



Parent Item Name: Hinge

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 03.01.29 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	103.0000	0.0596	0.250947	 B11-6-27	15	

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT020	103	
117494	103	117494

(6)

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DART AEROSPACE LTD	Work Order:	71223
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	J	Prototype Approval:	N/A
Date:	11-6-87	Date:	11-6-87	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.12	New Issue	KJ/JLM	
B	08.01.16	3.718 was 3.178	KJ/EC/DD	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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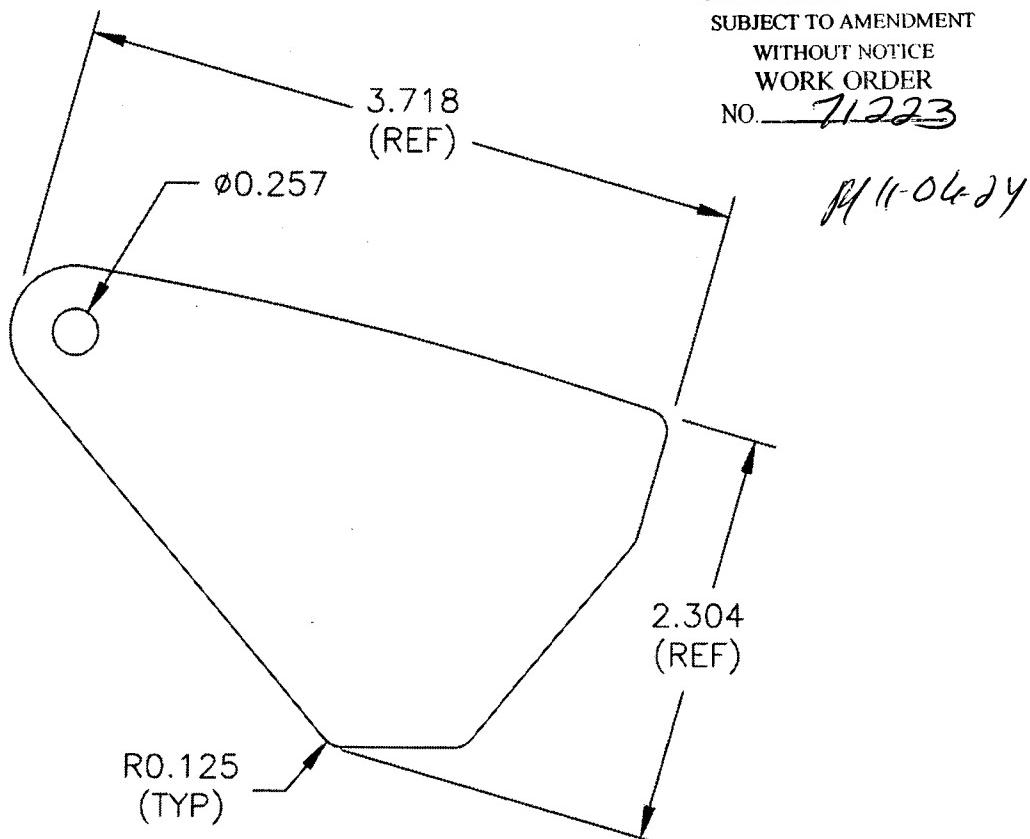
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3182	SHEET 1 OF 1
DATE		TITLE	SCALE
03.01.21		HINGE	1:1
A	03.01.21	NEW ISSUE	

RELEASED
03.01.21

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71223



D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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